

Date: Wednesday, 20/05/2009 1:53:18 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 48090C	
Estimate Number : 10356	
P.O. Number :	Part Number : D2279
This Issue : 20/05/2009 S.O. No. :	Drawing Number : D2279 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 47644C	Material :
Written By :	Due Date : 27/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>MF 09-05-21</u>	
Comment : Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.5435 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: 111786 B 9-6-24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D 2279
 Dwg Rev: D
 Prog Rev: D

B 9-6-24

(18)

2-Deburr if necessary B 9-6-24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-6-24

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/06/24

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Form As per Dwg D2279

07/06/24 (18)

07/07/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:53:18 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 48090C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/07/01 (X18)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMD 09/07/01

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-07-01

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

DEVEN

R 9/7/2 (18)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/07/07

Job Completion



W 09.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

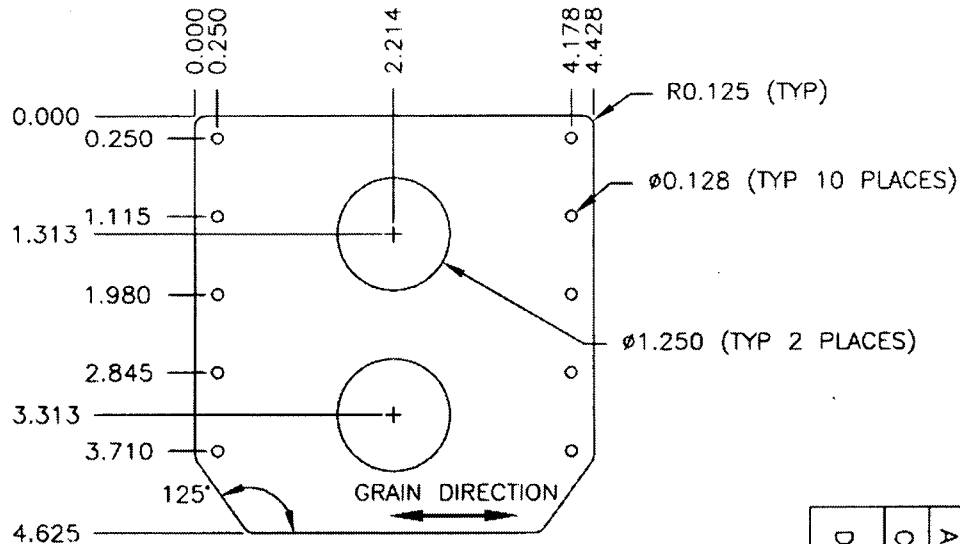
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

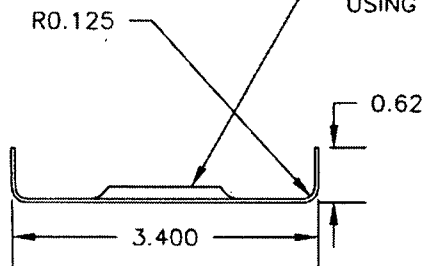


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
3W		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	KE	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



UNDER REVIEW

RELEASED

NOV 15 98
DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

#48090C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries